

ABSTRACT OF THE DISCLOSURE

5 (mont 98) A body implantable medical device (IMD) includes a first shell and a second
shell. The outer surfaces of the first and second shells are fabricated from a material
compatible with body fluids. The implantable medical device further includes a
battery enclosure defined by a cover and all or a portion of the first shell of the IMD
housing. The cover of the battery enclosure is disposed between the inner surfaces of
10 the first and second shells. An electrochemical cell, such as a flat liquid electrolyte
battery, is provided in the battery enclosure. Electronic circuitry, which may be
supported on a flexible wiring substrate, is provided between the inner surface of the
second shell and the cover of the battery enclosure. A hermetic seal is provided
between the cover of the battery enclosure and all or the portion of the first shell. The
15 hermetic seal is preferably a weld joint, such as a butt weld or a tumble weld joint.
The hermetic seal may also be established by a spanked weld joint between the cover
and all or a portion of the first shell. The battery enclosure cover may include a
coined edge and the hermetic seal is established by a weld joint between the coined
edge of the cover and a peripheral edge along all or the portion of the first shell.
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